

Work Order ID 75653***75653***

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Item ID:	D3510-041	Accept	*N900040100*	Setup	Start	*NS1*		
Revision ID:						Stop	*NS2*	
Item Name:	Skidtube Insert Assembly							
Start Date:	10/27/11	Start Qty:	1.00	*1*	Cust Item ID:			
Required Date:	10/28/11	Req'd Qty:	1.00	*1*	Customer:			

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
						Stop	
	QC:	Date:	SPC (Y/N):	Date:			*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* HAAS 1	HAAS CNC VERTICAL MACHINING #1 Memo HAAS CNC vertical machine #1	0.00	B.A	11/11/01		1	0		
	1-Machine as per Folio FA652 and Dwg D3510								
	2-Deburr								

Note: *-****.250" dia holes are to be opened to finish size by skidtube dept, and
missing .266" dia hole is to be drilled by skid dept.*****

130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00	B.A	11/11/01	1	0		
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140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00	RF	11.11.1	1	0		
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Shp Abv. 2

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Item ID:	D3510-041	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:				Stop		*NS2*
Item Name:	Skidtube Insert Assembly					
Start Date:	10/27/11	Start Qty:	1.00	*1*	Cust Item ID:	
Required Date:	10/28/11	Req'd Qty:	1.00	*1*	Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
					Stop		
	QC:	Date:	SPC (Y/N):	Date:			*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Skidtubes	Skidtubes	0.00							
	Memo	0.00							
	1-DrillL .266" Dia hole using DT8877B as per Dwg D3510								
	2-Counter bore wearplate holes as per Dwg d3510.								
	3-open wearplatre holes to .297 as per Dwg D3510.								
	4-Deburr								
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
170 *170* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00							

11-11-1

11-11-02(0)

1X0M-JWJ/02

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Item ID: D3510-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID:
Item Name: Skidtube Insert Assembly **Stop** *NS2*
Start Date: 10/27/11 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 10/28/11 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	<i>BR</i>	<i>11-11-2</i>	
190 *190* HandFinish Hand Finishing	HandFinishing Memo Install inserts as per Dwg D3510	0.00 0.00				1	<i>BR</i>	<i>11-11-2</i>	
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>M</i>	<i>11 - 11 - 02</i>	<i>(C)</i>	

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Item ID:	D3510-041	Accept	*N900040100*	Setup	Start	*NS1*		
Revision ID:						Stop	*NS2*	
Item Name:	Skidtube Insert Assembly							
Start Date:	10/27/11	Start Qty:	1.00	*1*	Cust Item ID:			
Required Date:	10/28/11	Req'd Qty:	1.00	*1*	Customer:			

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
						Stop	
	QC:	Date:	SPC (Y/N):	Date:			*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location:	0.00							
210 Packaging	Memo	PPP 75286	0.00						<i>10/27/11</i> ①
220	QC21- Final Inspection - Work Order Release	0.00							
220 QC	Memo	0.00							<i>10/27/11</i> ②
Quality Control									

*MF
11-10-02*

Picklist Print

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Work Order ID: 75653

Parent Item: D3510-041

Parent Item Name: Skidtube Insert Assembly

Start Date: 10/27/11

Required Date: 10/28/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-10-12 JLM

JPP Rev:B ALES-1032 and ALS4-428 insert now used FCN 1036 DD

IPP Rev:C Revised manufacturing steps for J.G. 08-09-29 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225 Insert		Purchased	No			190	Each	2,476.0000	6	6		BL 11-11-2	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST281	118696.	2476
	108696	624
	110768	62
	118386	860
	118966	930

ALS4-428-165 Purchased No 190 Each 485.0000 2 2 BL 11-11-2.
Inserts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	467	
117769✓	467	2.
FP-B	18	
114172	18	

ALS7-1032-130 Purchased No 190 Each 499.0000 **2** **2** BR 11-11-2.
Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST281	499	
117717	27	
118386	146	
118966	326	2.

M6061T6T3.50W.375 Purchased No 100 f 0.9631 **2.55** **2.6842105**
 6061-T6 RD Tube 3.50 X .375 W

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT014	0.9631	
17392	0.9631	

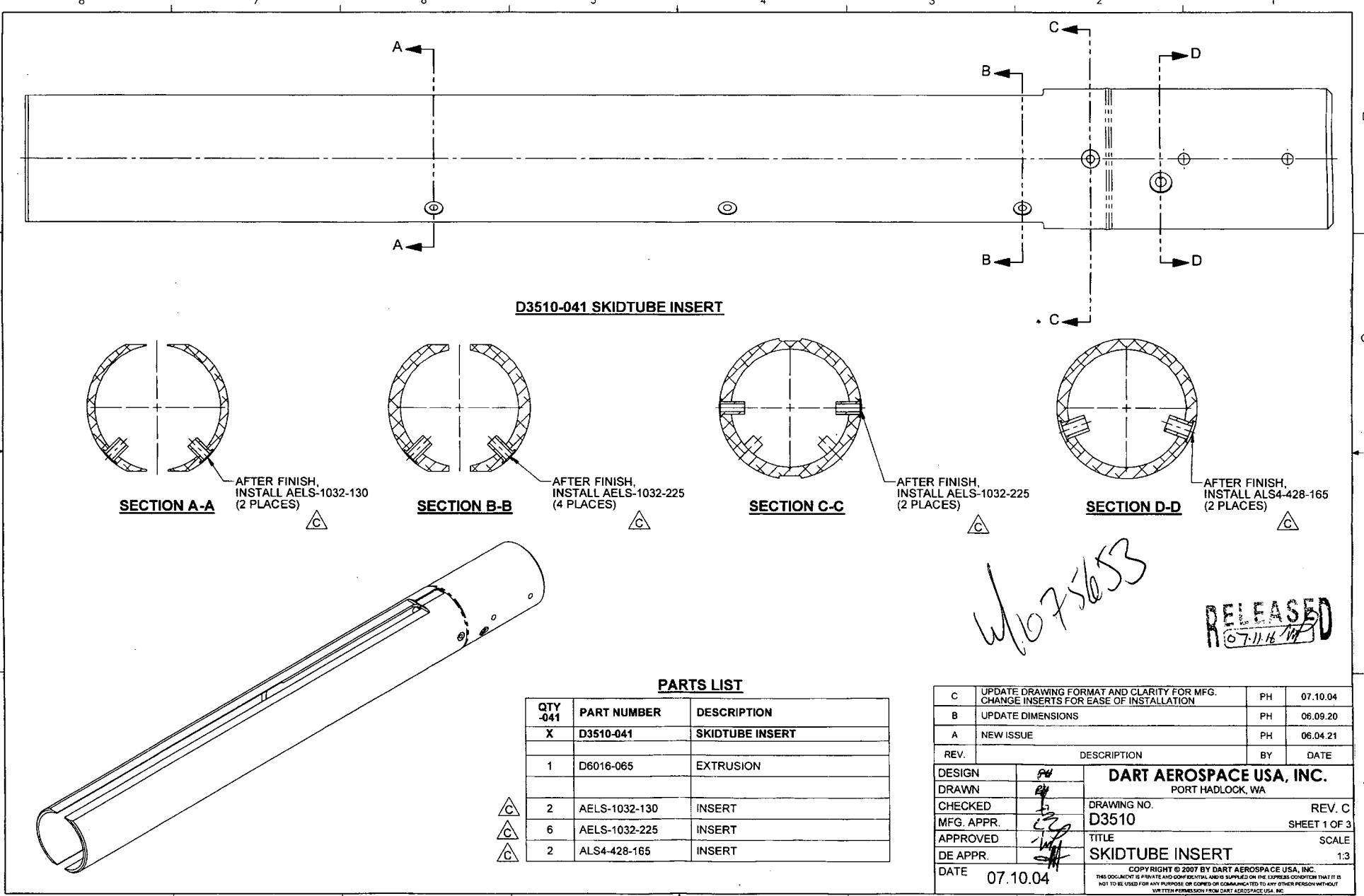
DART AEROSPACE LTD	Work Order:	75653
Description: Skidtube Insert	Part Number:	D3510-041
Inspection Dwg: D3510 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

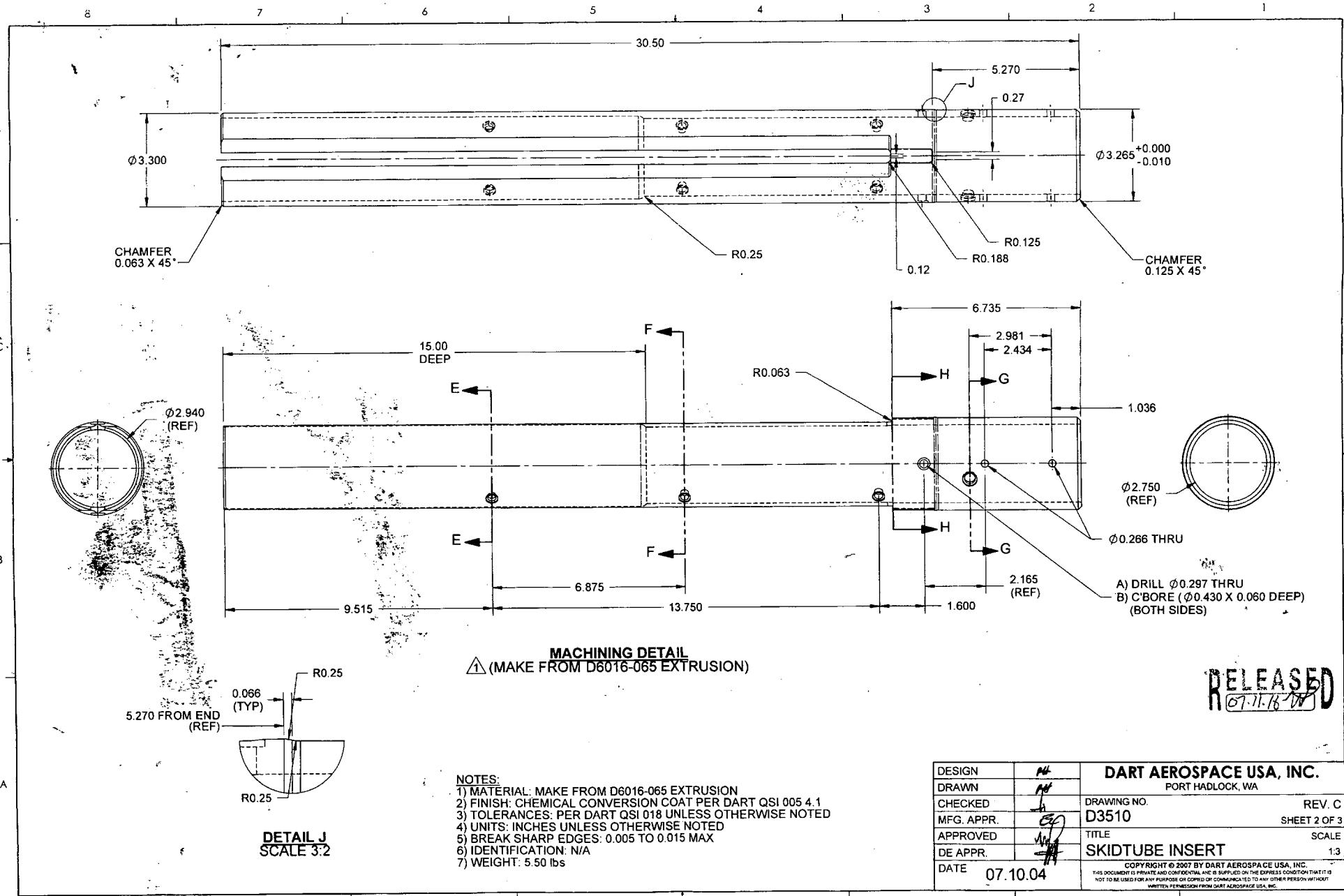
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.300	+/-0.010	3.300	/		Vern	CNC-08
Ø2.940	+/-0.010	2.940	/		"	
Ø2.750	+/-0.010	2.753	/		"	
R0.25 x 0.066	+/-0.010	.25x.066	/		RG	
15.00	+/-0.030	15.60	/		tape	MM.L-02
0.063 x 45°	+/-0.010 x 0.5°	.663 x 45°	/		Vern	CNC-08
0.125 x 45°	+/-0.010 x 0.5°	.125 x 45°	/		"	
5.270	+/-0.010	5.280	/		"	
3.265	+0.000/-0.010	3.259	/		"	
30.50	+/-0.030	31.50	/		tape	MM.L-02
9.515	+/-0.010	9.515	/		Vern	CNC-02
6.875	+/-0.010	6.875	/		"	"
13.750	+/-0.010	13.750	/		Tape	GA-12
1.600	+/-0.010	1.600	/		H-6	31006
2.165	+/-0.010	2.165	/		Vern	GA-01
6.735	+/-0.010					
2.981	+/-0.010					
2.434	+/-0.010					
1.036	+/-0.010					
Ø0.266	+0.006/-0.001	Ø0.266	/		Vern	GA-01
Ø0.391	+/-0.010	Ø0.393	/		"	"
Ø0.516 x 0.100	+/-0.010	Ø0.521 x 0.107	/		"	"

Measured by:	MML	B.R.	Audited by:	R.P.	Preliminary Approval:	
Date:	11/10/13	11/10/13	Date:	11.10.13	Date:	

Rev	Date	Change	Revised by	Approved
A	09.06.01	New Issue	KJ	
B	11.10.13	Dimension corrected	KJ	







NOTES:

- 1) MATERIAL: MAKE FROM D6016-065 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 5.50 lbs

DESIGN	<u>44</u>	DART AEROSPACE USA, INC.		
DRAWN	<u>44</u>	PORT HADLOCK, WA		
CHECKED	<u>b</u>	DRAWING NO.	REV. C	
MFG. APPR.	<u>EG</u>	D3510	SHEET 2 OF 3	
APPROVED	<u>W</u>	TITLE	SCALE	
DE APPR.	<u> </u>	SKIDTUBE INSERT	1:3	
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